

Work Order ID 85001

May-31-12 9:09:39 AM

85001

Page 1

Item ID: D212-725-1-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: ENGINE MOUNT DECK FITTING

Start Date: 5/31/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/31/12 Req'd Qty: 2.00

2

Customer:

Reference: rework to new rev

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4231

A U/R

105

0.00

105

Mill Conv

Memo

0.00

Conventional Milling Machine

PULL FROM STK:

2 X D212-725-1-111 B45608

REWORK/MILL PER NEW REV.

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

Crushed
parts not
found per
JL

W
120710

May-31-12 9:09:39 AM

Item ID: D212-725-1-111

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: ENGINE MOUNT DECK FITTING

Start Date: 5/31/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 5/31/12 **Req'd Qty:** 2.00 ***2***

Customer:

Reference: rework to new rev

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

140

Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: _____ Cad Plate per QQ-P-416F Class I Type
IIConformity sheet required

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

May-31-12 9:09:39 AM

Item ID: D212-725-1-111

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: ENGINE MOUNT DECK FITTING

Start Date: 5/31/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 5/31/12 **Req'd Qty:** 2.00 ***2***

Customer:

Reference: rework to new rev

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

Identify as per dwg & Stock Location: _____

0.00

170

0.00

Packaging

Memo

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

0.00

QC

Memo

Quality Control

Picklist Print

May-31-12 9:09:39 AM

Page 1

Work Order ID: 85001

Parent Item: D212-725-1-111

Start Date: 5/31/12

Required Date: 5/31/12

Parent Item Name: ENGINE MOUNT DECK FITTING

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-12-19 JLM
IPP Rev:B Added Cad Plating 07-07-23 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-725-1-111 ENGINE MOUNT DECK FITTING		Manufactured	No				Each	0.0000		2			

Linda Lacelle

From: Jean-Luc Menard <jmenard@dartaero.com>
Sent: May-30-12 1:41 PM
To: 'Linda Lacelle'
Subject: RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Conv milling mill as per new rev
Qc2
Qc8
I think we will have to re cad plate.

8/5001

JL

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, May 30, 2012 12:56 PM
To: 'Jean-Luc Menard'
Subject: RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

- 45608

Will you take them out of stk pls, write up what has to be done, and I'll make the w/o from that..
Thx
L

From: Jean-Luc Menard [mailto:jmenard@dartaero.com]
Sent: May-30-12 12:53 PM
To: 'Linda Lacelle'; 'Roberto Fuentes'
Cc: 'Eric Downing'; 'David Shepherd'; 'Mike Petsche'; 'David Shepherd'; 'Kim Johnston'
Subject: RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Yes we will be able to re-work them.
JLM

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, May 30, 2012 6:10 AM
To: 'Roberto Fuentes'; 'Jean-Luc Menard '
Cc: 'Eric Downing'; 'David Shepherd'; 'Mike Petsche'; 'David Shepherd'; 'Kim Johnston'
Subject: RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

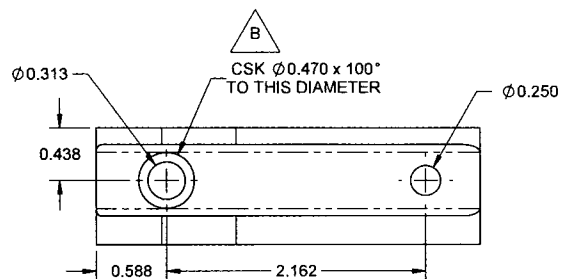
Only 2 x D212-725-1-111 in stk...JL can you let me know if these can be reworked..
L

From: Roberto Fuentes [mailto:rfuentes@dartaero.com]
Sent: May-29-12 6:47 PM
To: Linda Lacelle
Cc: Jean-Luc Menard ; Eric Downing; David Shepherd; Mike Petsche; David Shepherd; Kim Johnston
Subject: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

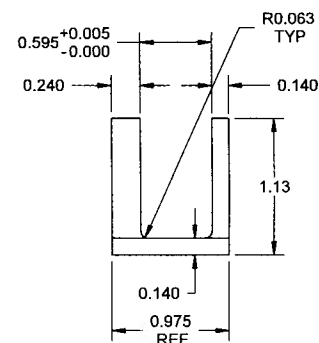
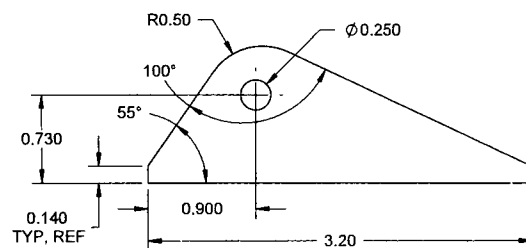
Hi Linda,

I just posted D4231-PB2 engine mount drawing for review and approve by production. If there is any W/O in progress need to be updated per this new drawing and check the stock. I just got the feedback from Eagle today.

Thanks,
Roberto



also 8507



~~7~~ 12.05.29

1) MATERIAL: AISI 4140 STEEL BAR
PER MIL-S-5626 OR AMS 6382/6349/6529
REF DART SPEC. M4140N-B
OR AISI 4130 STEEL BAR
PER MIL-S-6758 OR AMS 6345/6348/6370/6528
REF DART SPEC. M4130N-B
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi

2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED


4) UNITS: INCHES UNLESS OTHERWISE NOTED

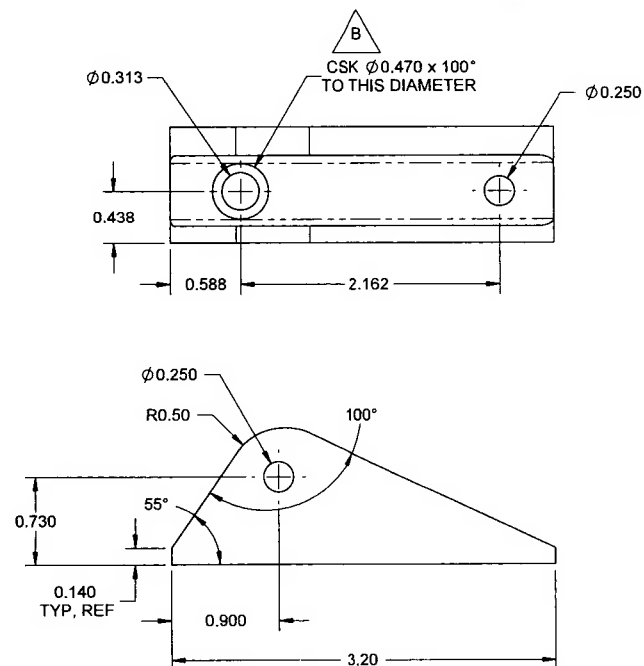
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 0.30 lbs

D212-725-1-109 SMALL ENGINE MOUNT, LH

PB2	CSK Ø0.470 x 100" WAS Ø0.446 x 45" CHAMFER (ZN D5-1, D5-2)	RF	12.05.29
A	MADE IN U.S.A.	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	JL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED			
MFG. APPR.		DRAWING NO.	REV. PB
APPROVED		D4231	SHEET 1 OF 1
DE APPR.		TITLE	SCALE
		ENGINE MOUNT	NT
DATE	12.05.29	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	



D212-725-1-110 SMALL ENGINE MOUNT, RH

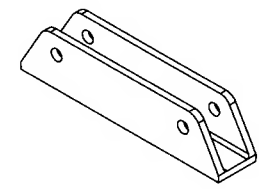
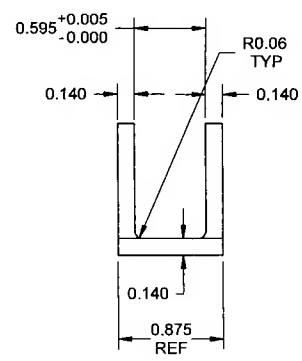
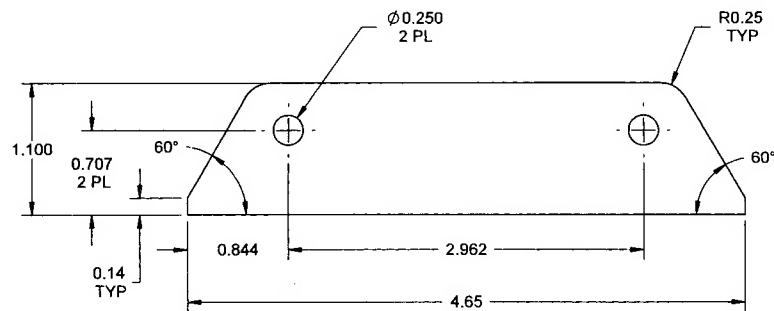
PRELIMINARY ISSUE

12.05.29

NOTES:

- 1) MATERIAL: AISI 4140 STEEL BAR
PER MIL-S-5626 OR AMS 6382/6349/6529
REF DART SPEC. M4140N-B
OR AISI 4130 STEEL BAR
PER MIL-S-6758 OR AMS 6345/6348/6370/6528
REF DART SPEC. M4130N-B
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.30 lbs

DESIGN	JL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4231	REV. PB2
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DATE	12.05.29		



D212-725-1-111 LARGE ENGINE MOUNT

NOTES:

- 1) MATERIAL: AISI 4140 STEEL BAR
PER MIL-S-5626 OR AMS 6382/6349/6529
REF DART SPEC. M4140N-B
OR AISI 4130 STEEL BAR
PER MIL-S-6758 OR AMS 6345/6348/6370/6528
REF DART SPEC. M4130N-B
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.47 lbs

PRELIMINARY ISSUE

12.05.29

DESIGN	JL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO. D4231	REV. PB2
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DATE	12.05.29		